

Fig 5

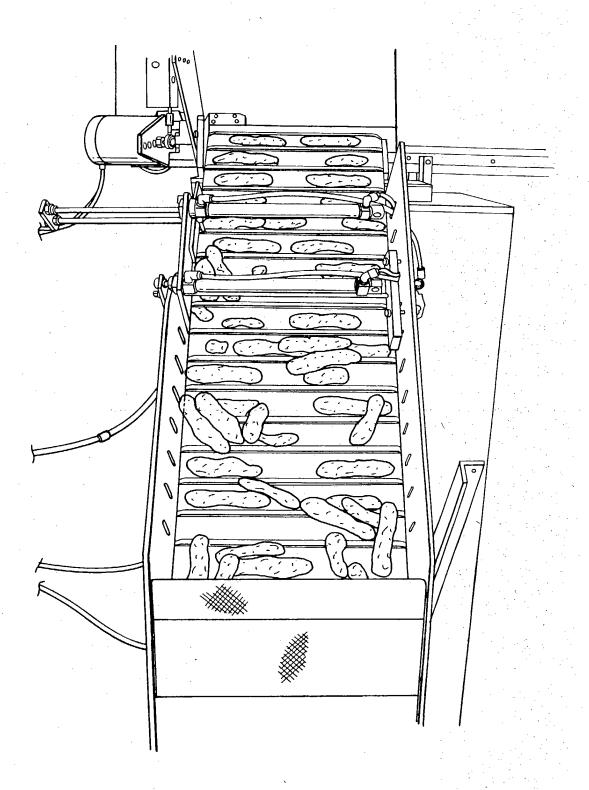


Fig. 6

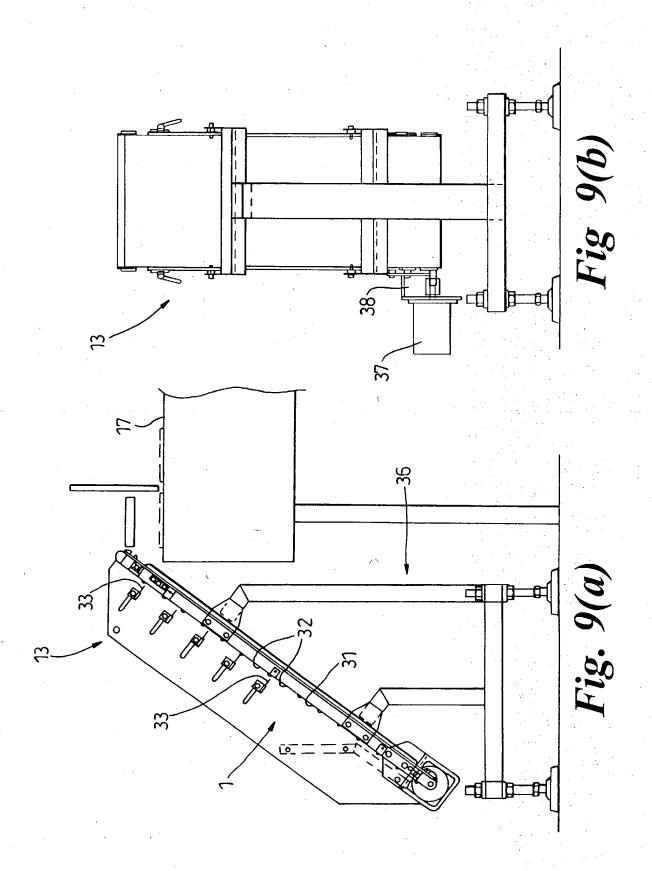
Conveyor sequencing 6 slice start 5 slice singulating

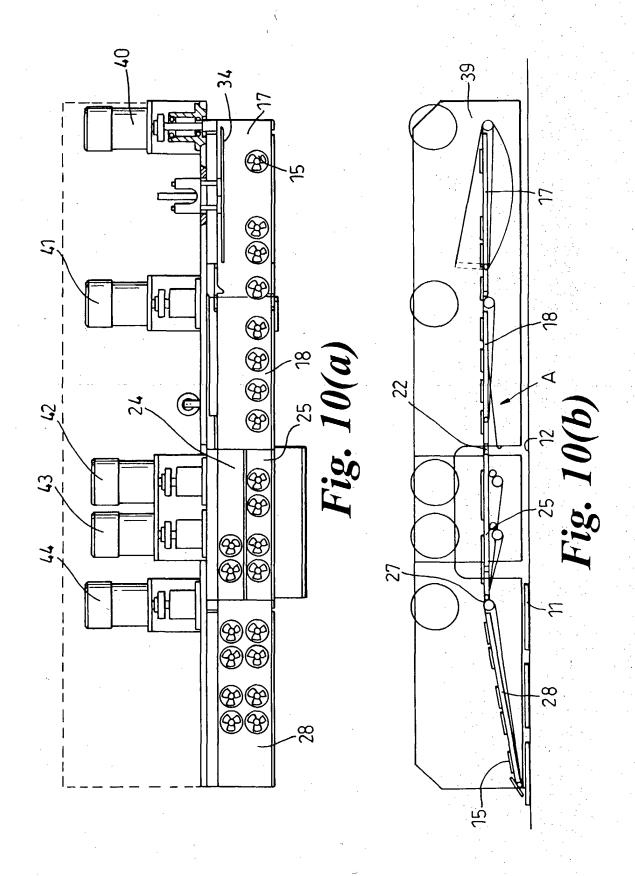
	ie. 2.00 ingredient slices per sec	:13 b1=40 g1=17 r2=10		a star		ands 2	0 500 1000 1500 2000 2500 0000 0			Fig 7
Six slices available at start, Singulator output 5 good slices Start point is immediately after size deposit on last bread slice	Ces from axis 1 to 2 (50mm increments) Time to next deposit start 1000 Time to next deposit start 1000 Since moves time 8 sitce Hypered Lansfelf Inne (axes 3-4) 531 200 Since moves time 1 541 8 sitce Hypered transfer inner axis 6 31 770	Axis 2 to 3 (or 2 to 4) slice transfer time Axis 5 ideashift time Singulaizate time	Event wis 2 axis 4 axis 5 axis 6 Singul Mays speed transfer 8 strees 11: 15: 15: 15: 17: 17: 17: 17: 17: 17: 17: 17: 17: 17	Composit 4 sinces	1 Transfer 1.2.3 6 276 276 276 276 276 276 276 276 276 2	12 235 235 235 13 276 276 14 276 276 276 15 276 276 16 277 276	18 276 276 19 276 275 20 276 276 20 276 276 21 236	24 247 247 247 247 247 247 247 247 247 2	Idle waiting for axis 6 to clear 30 544 544 544 544 46. Total placement cycle time	
	Axis 3 Axis 2 0.0.0.0 Shifting slices from 5 Axis 1 Shifting slices from 5 Axis 3 Axis 2 0.0.0.0 Shifting slices from 5 Axis 3 Axis 2 0.0.0.0 Shifting slices from 5 Axis 3 Axis 3 Axis 5 O.0.0.0 Shifting slices from 5 Axis 3 Axis 5 O.0.0.0 Shifting slices from 5 O.0.0.0 Shifting	Slan (house) (0000 00 0000 Aus 1 Notes 1 Notes 2 00000 Singulator Axes 3-4 00000 Singulator Axes 3-4	Siert President States States State	0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	Signt e-ent 21 2422 Axis 6 Axis 4 00 0000 00000 Axis 1	Axis 3 Axis 5 (sideshift)	2904 Adds 6 Adds 4 0000 000000000000000000000000000000	Beginning Anny 5 (soleshift)	

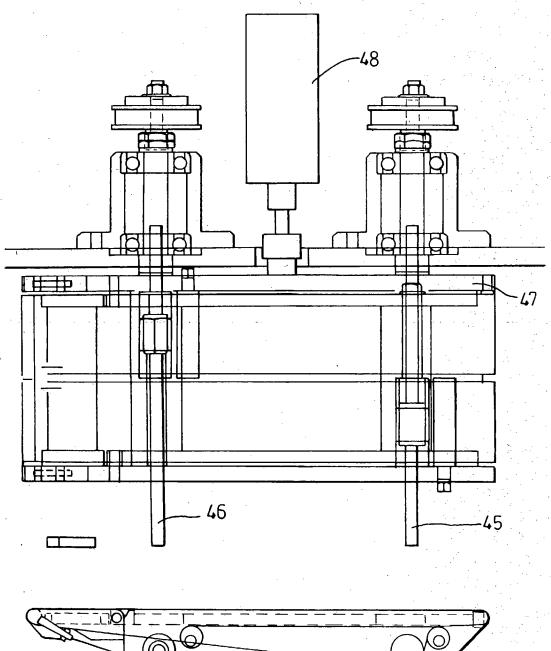
Proof of principle asserting atten 11-03-02

Proof of p	rinciple specification	11-03-02								
Module	Bell/conveyor detail	Slat detall	Angle to	Scraper detail	Scraper to belt distance mm	Acceleration mm/sec/sec.	Height from top of singulator belt to axis 1 surface	Hopper	Input end roller DIA	Discharge end roller DIA
Singulator					·					
Cucumber	300mmx2280m mx1.2mm,habast it FNB-5E	4.0mm Hx 8mm .W. 60mm pitch	52.5deg	20mm deep continuous strip polypropylene sheet 0.015in thick	6,5,5,5,5	14500	10mm	RIMEX vertical rear wall	Апу	24mm
Tomato	300mmx2280m mx1,2mm habaslit FNB-5E	4.0mm Hx 6mm W, 60mm pitch	52.5deg	20mm deep continious strip polypropylene sheet 0.015in	8,7,7,7,7	14500	10mm	RIMEX vertical rear wall	Any	24mm
Sausage	300mmx2280m mx1.2mm habasiit FNB-5E	4.5mm Hx 6mm W, 45.6mm pitch	52.5deg	no scrapers, 2 air operated deflectors stroke 200mm		11300	10mm	RIMEX vertical rear wall	Any	24mm
Module	Belt/conveyor detail	Slat detail	Angle to horizontal	Scraper detail	Scraper to belt distance mm	Acceleration mm/sec/sec.	Height from top of singulator belt to axis 1 surface	Hopper	Input end roller DIA	Discharge end roller DIA
AXIS 1	120mm widex350mm longx 0.8mm Habasit FAB 5ER	. N/A	Horizontal	N/A	N/A	4100			any	8.0mm
				Pusher blade to						
				align slices prior						
Pusher	N/A	. 1		to grabbing	1-2mm	4100	N/A		N/A	N/A
AXIS 2	120mm widex350mm longx0.8mm Habasit FAB- 5ER	N/A	Horizontal		N/A	4100	N/A		20mm	8.0mm
				[
Module	Selt/conveyor detail	Stat detail	Angle to horizontal	Scraper detail	Scraper to belt	Acceleration mm/sec/sec.	Height from top of singulator belt to axis 1 surface	Hopper	Input end roller	Discharge end roller DIA
AXIS 3	60mm widex250mm longx0.8mm Habasit FA8- 5ER	N/A	Horizontal	N/A	N/A	4100	N/A		20mm	8.0mm
-										
AXIS 4	60mm widex250mm longx0.8mm Habasil FAB- 5ER	N/A	Horizontal	N/A	N/A	4100	N/A		20mm	B.Omm
AXIS 5	Linear unit moving Axis3 and 4,120mm stroke	, N/A	Horizontal	N/A	N/A	4100	N/A		N/A	N/A
AXIS 8	120mm widex295mm longx0.8mm Habasit FAB- 5ER	N/A	7.5	N/A .	N/A	4000Accn 2000Dccn	N/A		20mm	8.Omm
Camera	DT/Hitachi KP-3 Camera 600mm above conveyor	N/A		I	I	<u> </u>	<u>. </u>			
Other considerations	Facility for second camera to record									

Fig 8







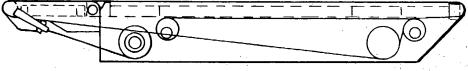


Fig 11

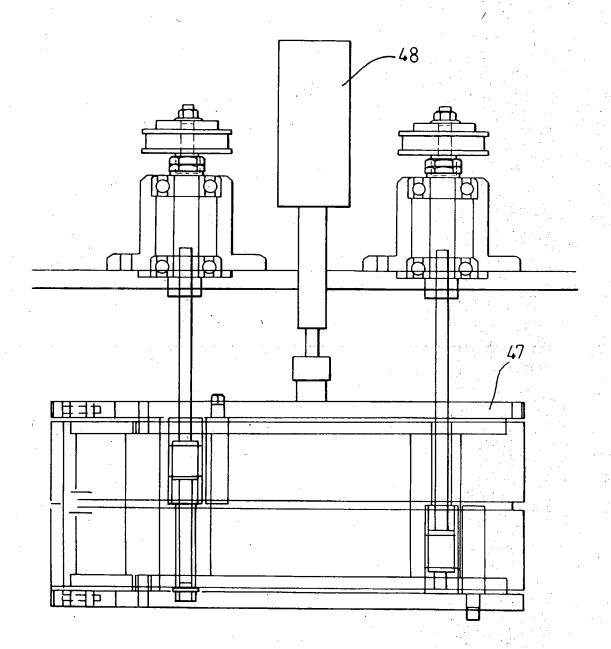


Fig. 12